

Work Order ID 59681

Wednesday, June 09, 2010 1:13:15 PM



Page 1

Item ID: D3697-4

Accept



Setup Start



Revision ID:

Item Name: Support Plate, RH

Stop



Start Date: 6/9/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 6/24/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: *10-6-09*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3697

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3697 ☐ Dwg Rev: *B* ☐ Prog Rev: *B*

☐

grain direction along 3.44"

☐ 2- Deburr if necessary

SP 10/6/10

10-6-10



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-6-10

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Solae10



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|-----------------------------------|--|----------------------|-------------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 Brake NC Brake NC | NC BRAKE Memo Bend as per Dwg D3697 | 0.00 0.00 | | | | | | | |
| | | | SB 08/04/16 | | | | | | |
| 140 QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | | | | | |
| | | | Subcheck | | | | | | |
| | | | (x8) | | | | | | |
| 150 Small Fab Small Fab | Small Fab Memo 1- counter sink hole as per dwg D3697 | 0.00 0.00 | | | | | | | |
| | | | 9506/16 (8) | | | | | | |

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Page 3

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Required Date: 6/24/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|-----------------------------------|--|----------------------|---------|--------|--------------|---------------|----------------|------------------|--|
| 160 QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | | | | | |
| 170 Packaging Packaging | Identify as per dwg & Stock Location: <u>W/A</u> Memo | 0.00 0.00 | | | | <u>EZ</u> | <u>10-6-16</u> | | |
| 180 QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | <u>10/06/17</u> <u>MF</u> <u>10-6-16</u> |

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, June 09, 2010 1:13:19 PM

Page 1

Work Order ID: 59681

Parent Item: D3697-4

Parent Item Name: Support Plate, RH

Comments: IPP Rev:A 08-04-25 new issue DD verified by:EC
IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec

Start Date: 6/9/2010

Required Date: 6/24/2010

Start Qty: 4.00

Required Qty: 4.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6S.050 | | Purchased | No | | | 100 | sf | 164.0900 | 0.4569 | 1.923789 | | | |



6061-T6 .050 Sheet



1810-b-16

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT | 128 | |
| 114799 | 128 | |
| MAT21 | 36.09 | |
| 110791 | 4.5 | |
| 113216 | 31.59 | |

110791

8

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

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|--|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 59681 |
| Description: Support Plate, RH | | Part Number: | D3697-4 |
| Inspection Dwg: D3697 Rev: B | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.098 | +0.004/-0.001 | .100 | ✓ | | | |
| 0.38 | +/-0.030 | .377 | ✓ | | | |
| 0.75 | +/-0.030 | .746 | ✓ | | | |
| 0.75 | +/-0.030 | .751 | ✓ | | | |
| 0.28 | +/-0.030 | .28 | ✓ | | | |
| 2.25 | +/-0.030 | 2.252 | ✓ | | | |
| 3.50 | +/-0.030 | 3.505 | ✓ | | | |
| 1.86 | +/-0.030 | 1.855 | ✓ | | | |
| 3.44 | +/-0.030 | 3.444 | ✓ | | | |
| 1.80 | +/-0.030 | 1.808 | ✓ | | | |
| 0.050 | +/-0.010 | .050 | ✓ | | | |
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|------------------------|----------------------|----------------------------|-----|
| Measured by: IR | Audited by: S | Prototype Approval: | N/A |
| Date: 10-6-16 | Date: 10/6/16 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 08.09.04 | New Issue | KJ/DD | DD |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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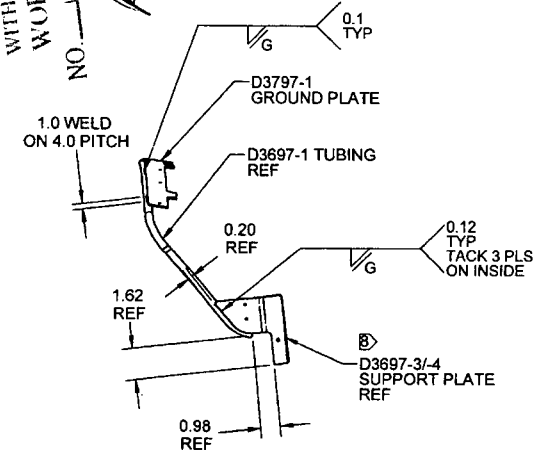
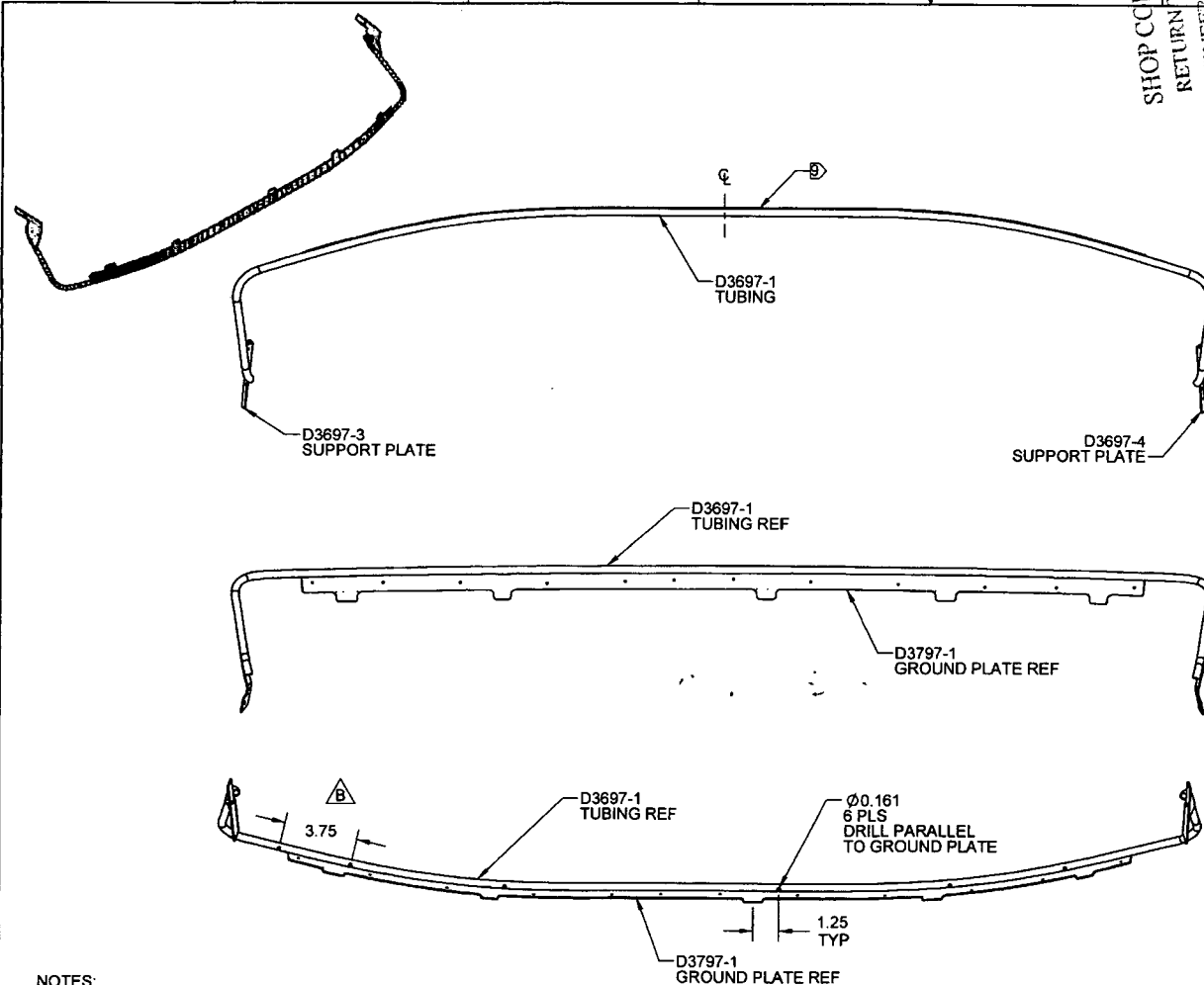
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NOTE: Date & initial all entries

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK CENTER
NO. 5-26851-
P10-6-09



PART LIST

| QTY -041 | PART NUMBER | DESCRIPTION |
|-------------|-------------|---------------|
| X | D3697-041 | TUBE ASSEMBLY |
| 1 | D3697-1 | TUBING |
| 1 | D3697-3 | SUPPORT PLATE |
| 1 | D3697-4 | SUPPORT PLATE |
| 1 | D3797-1 | GROUND PLATE |

| | | | |
|------------|--|--|--------------|
| B | REMOVE POWDER COAT & MASKED HATCHED AREAS. SHEET 1 ZONE A,8; ADD Ø0.161 HOLE. SHEET 1 ZONE B,7 | RF | 08.06.02 |
| A | NEW ISSUE | RF | 08.05.26 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | RF | DRAWING NO. | REV. B |
| MFG. APPR. | RF | D3697 | SHEET 1 OF 3 |
| APPROVED | RF | TITLE | SCALE |
| DE APPR. | RF | TUBE ASSEMBLY | NTS |
| DATE | 08.06.02 | COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

- NOTES:
- 1) WELD PER QSI 004
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.55 lbs
 - 8) LOCATE D3697-3/4 ON D3697-1 USING DT9009 WELDING JIG
 - 9) CENTER D3797-1 GROUND PLATE ON D3697-1 TUBING

D3697-041 TUBE ASSEMBLY

| W/O: | | WORK ORDER CHANGES | | | | | |
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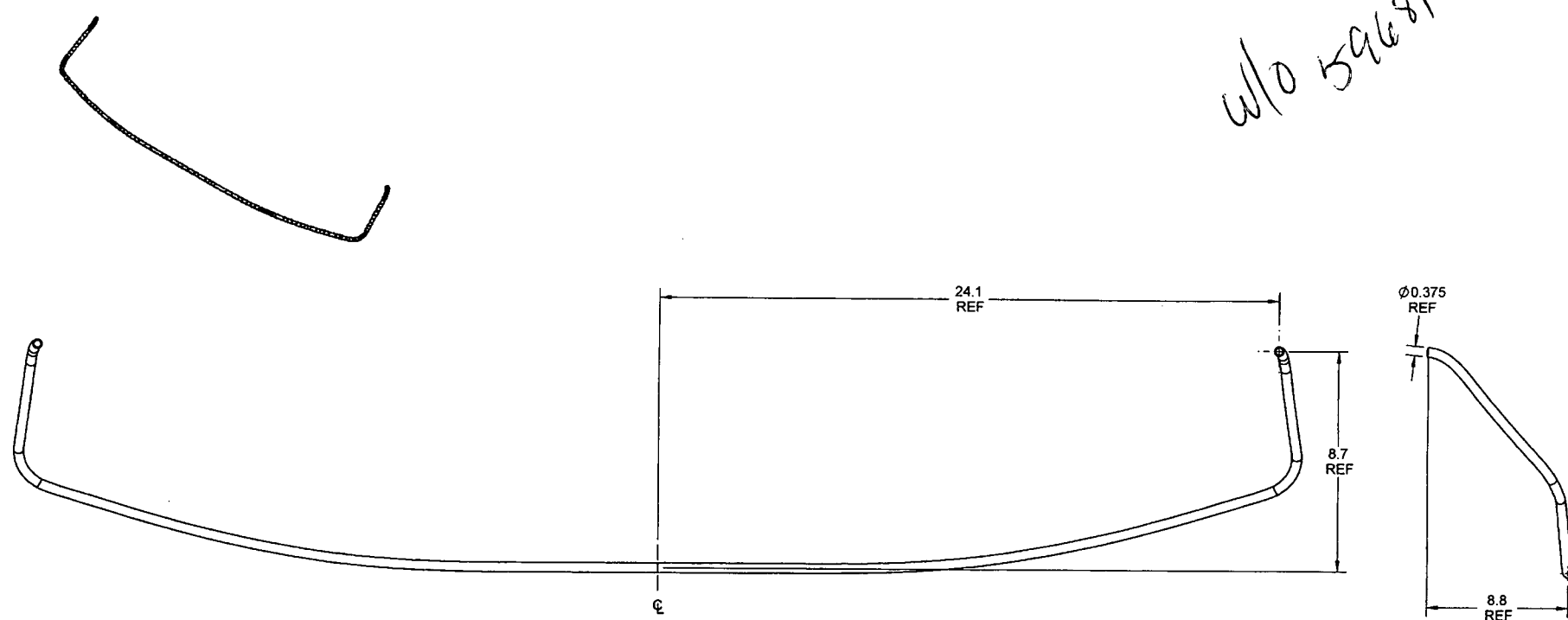
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NOTE: Date & initial all entries

w/o 59681



D3697-1 TUBING

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 (WWW-T-700/6) ALUMINUM TUBING $\varnothing 0.375 \times 0.049$ WALL (REF. DART SPEC. M6061T6T0.375W0.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lb
- 8) FABRICATE USING TEMPLATE DT9003

RELEASED
06-07-08

| | | | |
|------------|-----------------|--|---------------|
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | RF | DRAWING NO. D3697 | REV. B |
| MFG. APPR. | RF | | SHEET 2 OF 3 |
| APPROVED | RF | TITLE | SCALE |
| DE APPR. | RF | TUBE ASSEMBLY | NTS |
| DATE | 08.06.02 | <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

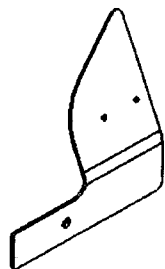
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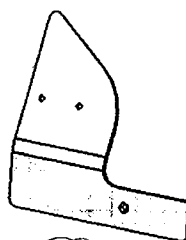
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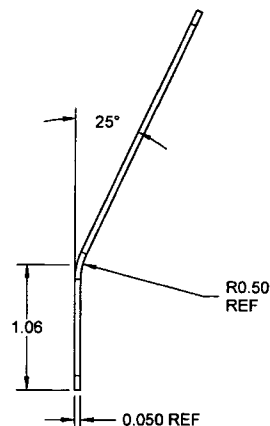
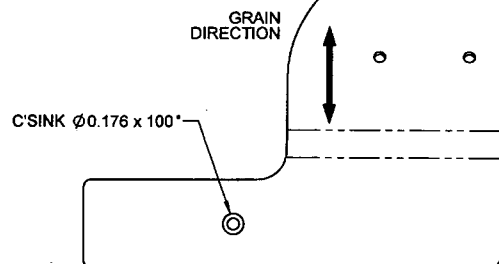
NOTE: Date & initial all entries



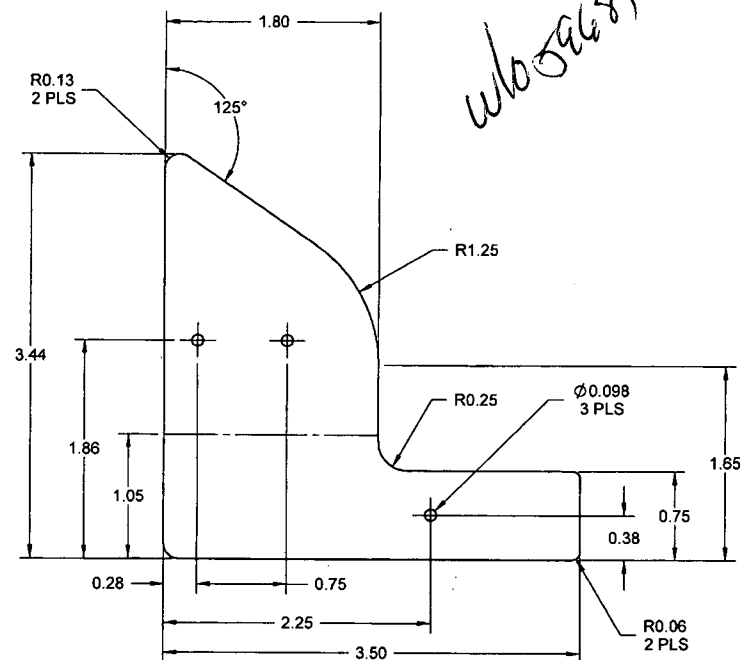
D3697-3 SUPPORT PLATE (LH SHOWN)



D3697-4 SUPPORT PLATE (RH SHOWN)



D3697-3 SUPPORT PLATE (LH SHOWN)
(D3697-4 SUPPORT PLATE OPPOSITE)
(MAKE FROM D3697-3F FLAT PATTERN)



D3697-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) SHEET 0.050 THICK (REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

RELEASED
 08-07-02

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|------------|----------|--|--------------|
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | RF | DRAWING NO. D3697 | REV. B |
| MFG. APPR. | RF | TITLE TUBE ASSEMBLY | SHEET 3 OF 3 |
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